

Date: Monday, 3/26/2007 3:23:36 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	: RING	
Job Number	: 31489		Part Number	: D2655 <i>up</i>	
Estimate Number	: 10608		Drawing Number	: D2655 REV B	
P.O. Number	: <i>N/A</i>		Project Number	: N/A	
This Issue	: 3/26/2007 S.O. No. : <i>N/A</i>		Drawing Revision	: B	
Prsht Rev.	: NC		Material	: <i>N/A</i>	
First Issue	: <i>N/A</i>		Due Date	: 4/30/2007 Qty: 20 Um: Each	
Previous Run	: 29334				
Written By					
Checked & Approved By					
Comment	: Est. D 00-06-22 Removed P/O for powder coat EC Est Rev:E Now on Waterjet 06-10-04 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	M1018B400X250	Inventory		
		Comment: Qty.: 0.2835 f(s)/Unit Total : 5.6700 f(s) 1018 ASTM A36 .250" thk bar x 4.0"		(20)
		Batch: <i>M1018B400X 18 07-06-27</i>		
2.0	WATER JET	FLOW WATER JET		
		Comment: FLOW WATER JET 1-Cut as per Dwg D2655 Dwg Rev: <i>B</i> Prog Rev: <i>B</i>		
		2-Deburr if necessary	<i>HB 07-06-28</i>	(20)
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE		(20)
4.0	QC8	SECOND CHECK		
		Comment: SECOND CHECK	<i>HB 07-06-28</i>	<i>Counted X70</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1		
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Tumble - .030 Radius 2-Deburr any rough edges after tumbling		<i>SAD 07/06/29</i>
				(20)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/07/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: RING

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Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



coated

Comment: INSPECT WORK TO CURRENT STEP

7.0 POWDER COATING

SPRAY painting

POWDER COATING



Delfleet Blue

Comment: POWDER COATING

Powder Coat per QSI 005 4.3.5.1

+ clear

Atelier debosselzge

Issue P.O.

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Stock unpainted

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: sty33

FINAL INSPECTION/W/O RELEASE



1/25

(16)

(16)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u ST-07-06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31489
Description: Ring	Part Number:	D2655
Inspection Dwg: D2655	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>JB</u>	Audited by:		Prototype Approval:	N/A
Date:	<u>07-06-27</u>	Date:		Date:	N/A

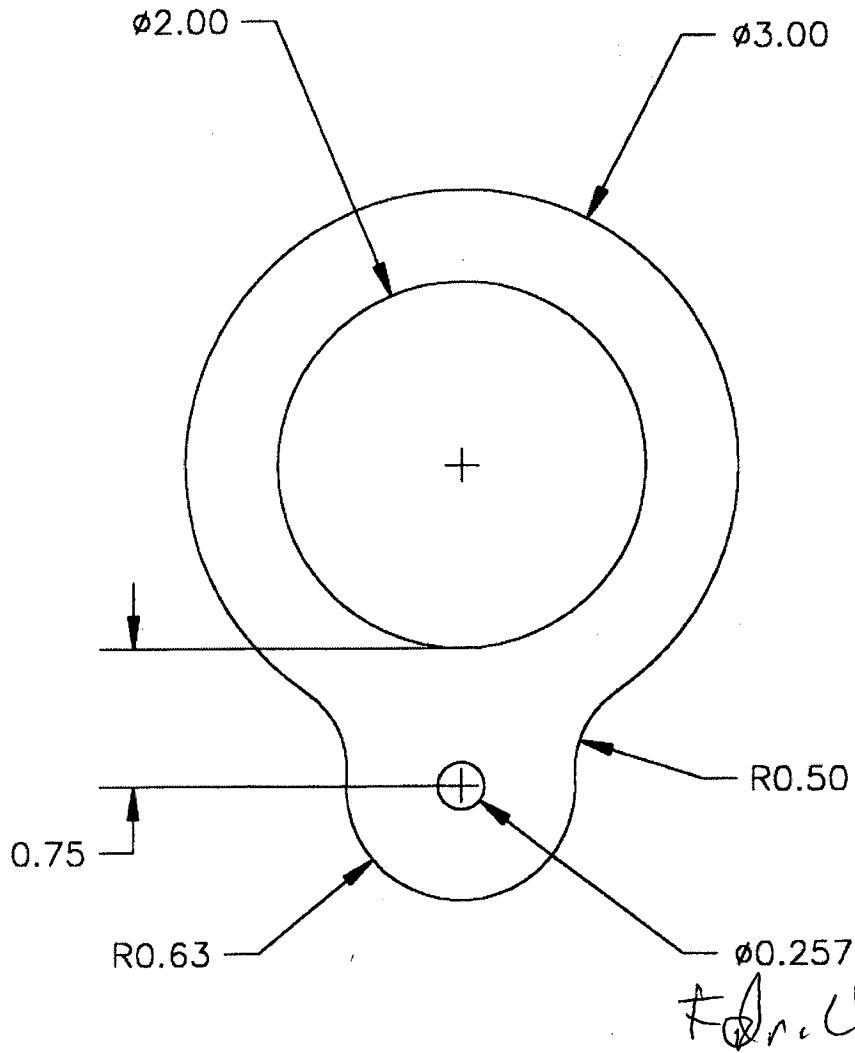
Rev	Date	Change	Revised by	Approved
A	06.10.12	New Issue	KJ/JLM	JLH



DA COPY IS
SHEET 1 OF 1

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED	APPROVED	DRAWING NO. D2655 REV. B SHEET 1 OF 1
DATE		TITLE RING SCALE 1:1
97:07:07		
A	97:03:25	NEW ISSUE
B	97:07:07	ADD ASTM A36 TO MAT. SPEC.

RELEASED
470711 DS



NOTE: DEBURR ALL SHARP EDGES

MATERIAL: AISI 1018/1020/1025 OR ASTM A36 0.250 THICK

FINISH: POWDER COAT PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31489